Work Order ID 53111

October 22, 2009 9:08:47 AM

Item ID: DSI 9447-011 **Accept** **Setup Start** **Stop**

Revision ID: A

Item Name: Latch Adjustment

Start Date: 22/10/2009 **Start Qty:** 4.00 **Cust Item ID:**

Required Date: 30/10/2009 **Req'd Qty:** 4.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** 22-10-22 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**: DSI 9447 / A									
100		0.00							
DC	**Memo**	0.00							
Document Control	Photocopy bluefile &type labels per PPP DSI 9447-011 CHG001								
110	Pick Kit	0.00							
Packaging	**Memo**	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
QC	**Memo**	0.00							
Quality Control									

Work Order ID 53111

October 22, 2009 9:08:47 AM

Item ID: DSI 9447-011 **Accept** **Setup Start** **Stop**

Revision ID: A

Item Name: Latch Adjustment

Start Date: 22/10/2009 **Start Qty:** 4.00 **Cust Item ID:**

Required Date: 30/10/2009 **Req'd Qty:** 4.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00				9/10/09		54	
Packaging	**Memo**	0.00							
Packaging	Identify and pack for shipping as per PPP DSI 9447-011 Location: _____ PPP rev: A								
140	QC21- Final Inspection - Work Order Release	0.00				09/11/02			
QC	**Memo**	0.00							
Quality Control									

CMF
09-10-30

Picklist Print

October 29, 2009 10:11:49 AM

Work Order ID: 53111

Parent Item: DSI 9447-011RevA

Parent Item Name: Latch Adjustment

Comments:

Start Date: 10/22/09 **Required Date:** 10/30/09

Start Qty: 4.00 **Required Qty:** 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3895-1RevA Doubler		Manufactured	No				Each	7.0000	4.0000		9/10/09 SD	

Warehouse Location	Loc Qty	Loc Code
HONG KONG		
ST	3	
46897	4	

46897 SD

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-589 REV. E AND EARLIER
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-589 REV. 1 AND EARLIER
REF. TCCA STC: SH92-41
REF. FAA STC: SH1012NE
REF. AUSTRIAN STC: ACG.21NE2.093

The purpose of this DSI is to provide instruction for recessing the forward upper latch of the D35X-589-041/-042/-043 Side Door Assemblies for compatability with OEM sliding doors. Without this modification the OEM sliding door may contact the upper latch as the door is opened.

The DSI 9447-011 Latch Adjustment Kit may be installed as follows:

1) Remove sliding door guide (p/n 350A21-1375-21/-20) and shim (p/n 350A21-1376-20) from existing door and relocate to D35X-589-041/-042/-043 door assembly. See Figure 2 for drilling and repair details. Install using existing hardware.
2) Mark around the edge of the upper forward D2586 door latch on the outer door surface.
3) Remove the upper forward D2586 door latch and trim the hole to the line marked in the previous step. D2586 door latch should now be able to pass through the hole.
4) Position the D3895-1 doubler on the inside of the door with the cutout centered over the newly enlarged hole.
5) Transfer drill 16x ∅0.129 (#30 drill) from the doubler to the D35X-589-041/-042/-043 side door. Countersink the 16 holes ∅0.179 x 100° from the outside of the door. Deburr holes and attach D3895-1 doubler to the D35X-589-041/-042/-043 door with qty. (16) MS20426AD4 rivets. See Figure 1.
6) Re-install the D2586 door latch per D350-589 and/or ICA-D350-589.
7) Verify that the door closes and latches correctly. Adjust latches per ICA-D350-589.
8) Apply blade tape (Ref. 3M p/n 8560-2) to the D35X-589-041/-042/-043 side door to prevent contact wear from the OEM sliding door.

There is no weight and balance change for the installation of the DSI 9447-011 latch adjustment kit.

The D3895-1 doubler will be included with D35X-589-041/-042/-043 kits at CHG 3 and subsequent.

PARTS LIST

QTY. -011	PART NUMBER	DESCRIPTION
X	DSI 9447-011	Latch Adjustment Kit
1	D3895-1	Doubler

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 5311
09-10-20

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

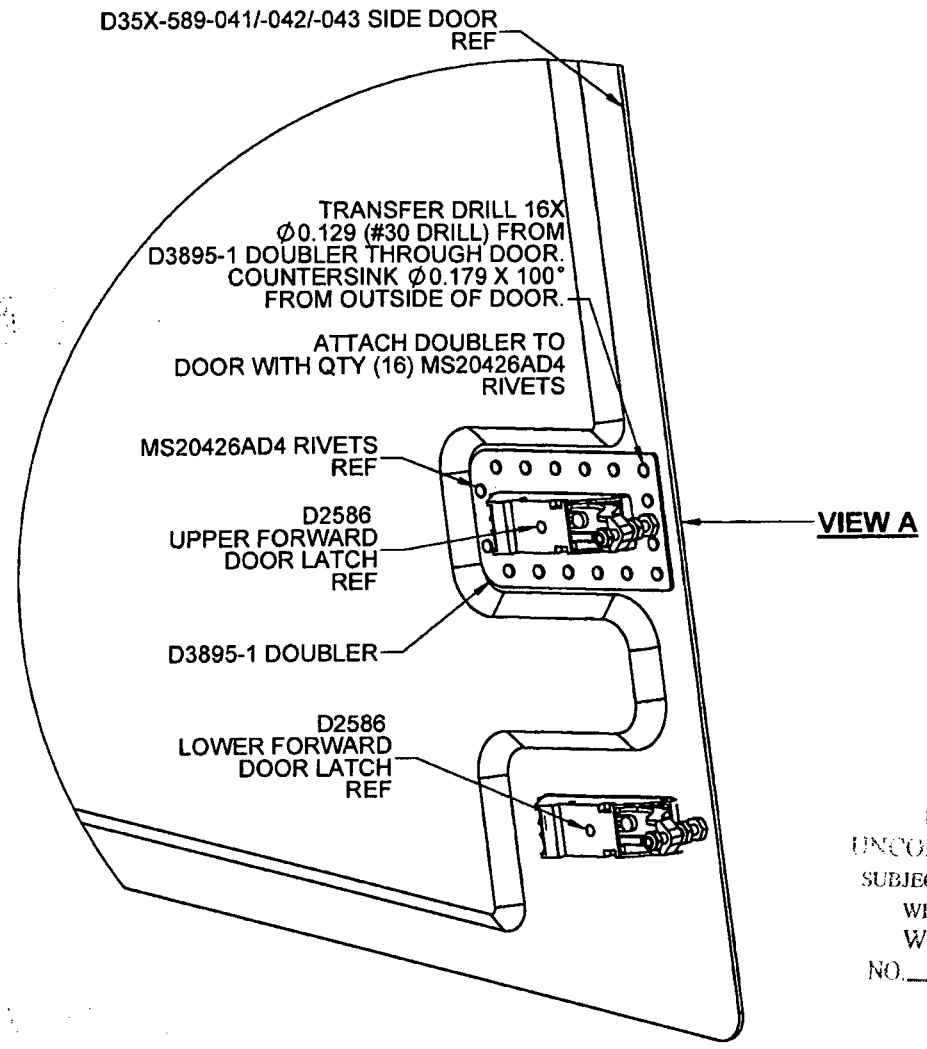
APPROVED
BY: _____
D. SHEPHERD (DE # 02)

DATE: 09.02.04
CERT. NO.: SH92-41
ISSUE NO.: 7

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE		09.02.04

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. DSI 9447	REV. A
MFG. APPR.	N/A		SHEET 1 OF 3
APPROVED		TITLE LATCH ADJUSTMENT	SCALE NTS
DE APPR.			
DATE	09.02.04		

COPYRIGHT © 2009 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53111

FIGURE 1: DSI 9447-011 LATCH ADJUSTMENT KIT INSTALLATION

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: _____
D. SHEPHERD (DE # 02)

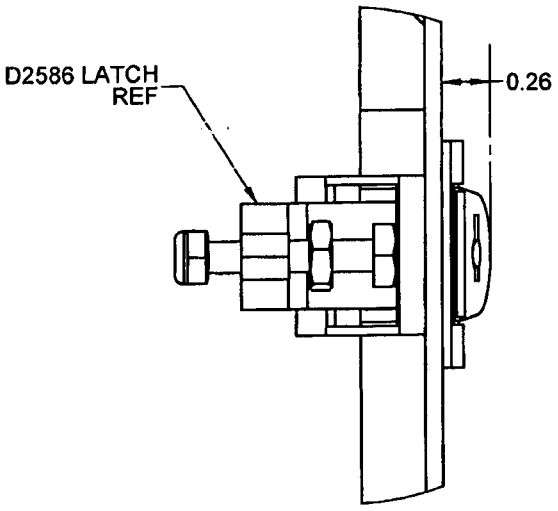
DATE: 09.02.04
CERT. NO.: SH92-41
ISSUE NO.: 7

DESIGN	
DRAWN	
CHECKED	
MFG. APPR.	N/A
APPROVED	
DE APPR.	
DATE	09.02.04

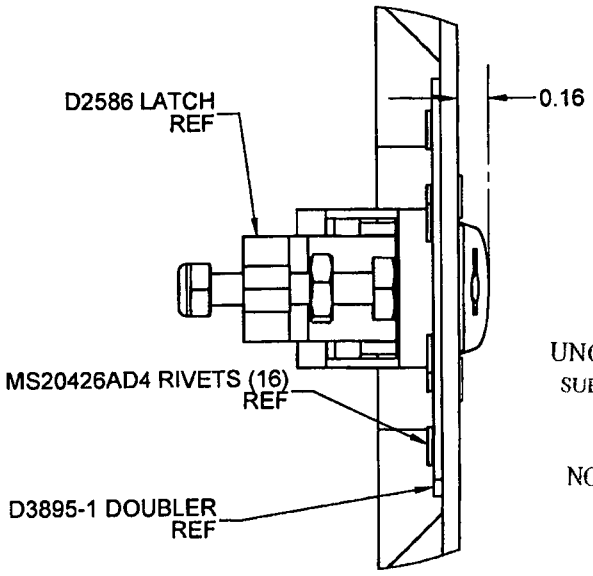
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. DSI 9447 REV. A
SHEET 2 OF 3
TITLE LATCH ADJUSTMENT SCALE NTS

COPYRIGHT © 2009 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



VIEW A - BEFORE DSI 9447-011



VIEW A - AFTER DSI 9447-011

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53111

AT EACH FASTENER LOCATION FOR P/N 350A21-1375-21/-20 GUIDE

- DRILL Ø0.38 HOLE THRU DOOR. REMOVE THE FOAM INNER LAYER 0.25 AROUND THE HOLE BETWEEN THE INNER AND OUTER SKINS.
- APPLY TAPE OR EQUIVALENT BACKER TO THE INNER SIDE OF THE HOLES TO PREVENT EPOXY FILLER FROM GOING THROUGH.
- FILL THE CAVITY BETWEEEN THE SKINS COMPLETELY WITH HYSOL 934NA MIXED WITH MILLED GLASS FIBERS TO A RATIO OF 10:1 OR METALSET A4.
- ALLOW THE MATERIAL TO CURE.
- DRILL Ø0.204 (#6 DRILL) THRU 2 PL
- SEE REPAIR DETAIL.

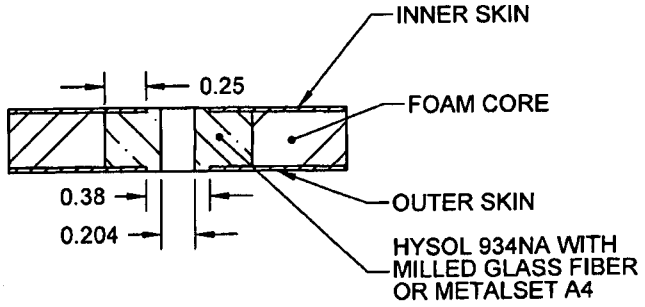


FIGURE 2
GUIDE INSTALLATION
REPAIR AND DRILLING DETAIL

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: _____
D. SHEPHERD (DE # 02)

DATE: 09.02.04
CERT. NO.: SH92-41
ISSUE NO.: 7

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. DSI 9447 REV. A SHEET 3 OF 3
MFG. APPR.	N/A	
APPROVED		TITLE LATCH ADJUSTMENT SCALE NTS
DE APPR.		
DATE	09.02.04	

COPYRIGHT © 2009 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.